

Work Order ID 63675

Tuesday, November 09, 2010 2:27:32 PM



Page 1

Item ID:	D3953-9	Accept		Setup	Start	
Revision ID:						
Item Name:	Gas Spring Washer				Stop	
Start Date:	11/9/2010	Start Qty: 8.00				
Required Date:	11/16/2010	Req'd Qty: 8.00				
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>10-11-9</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3953	C								

100		0.00							
Hardinge		0.00							
Hardinge CNC Lathe Small									
	Memo								
	TURN AS PER FOLIO FA855 & DWG								
	FOLIO REV: <u>1/1</u>								
	DWG REV: <u>1/1</u>								
	DEBURR								
110		0.00							
QC		0.00							
Quality Control									
	Memo								

ml 10.11.11 8

ml 10.11.11 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3953-9

Accept

Setup Start

Revision ID:

Stop

Item Name: Gas Spring Washer

Start Date: 11/9/2010 Start Qty: 8.00

Required Date: 11/16/2010 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	H. A 10/11/12			8			
130 Packaging Packaging	Identify as per dwg & Stock Location: 101 Memo	0.00 0.00	10/11/12 (8)						
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00	10/11/12 (8)						

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NOTE: Date & initial all entries

Picklist Print

Tuesday, November 09, 2010 2:27:31 PM

Page 1

Work Order ID: 63675



Parent Item: D3953-9



Parent Item Name: Gas Spring Washer

Start Date: 11/9/2010

Required Date: 11/16/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue 09.10.13 DD verified by:EC
as per dwg revC DD 10.03.02 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MDELRINR0.750

Purchased

No

100

f

58.3400

0.05

0.421053



10.11.11

Delrin Round Bar 0.75"

Location

Loc Qty

Loc Code

MAT050

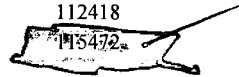
58.34

112418

0.12

115472

58.22



11

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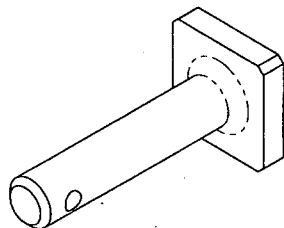
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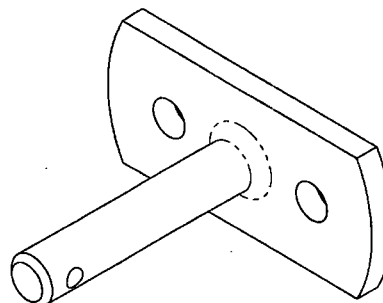
NOTE: Date & initial all entries



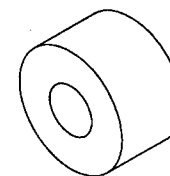
D3953-1 GAS SPRING BRACKET
(FULL LID)



D3953-3 GAS SPRING STUD, LID



D3953-5 GAS SPRING STUD, BASE

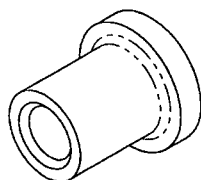


D3953-7 GAS SPRING SPACER

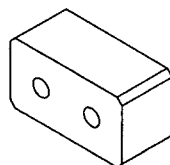


D3953-9 GAS SPRING WASHER

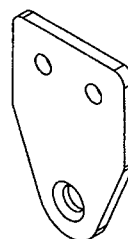
63695



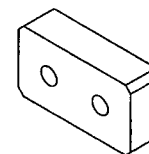
D3953-11 GAS SPRING SPACER



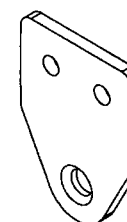
D3953-13 GAS SPRING SPACER
(FULL LID)



D3953-15 GAS SPRING BRACKET
(SPLIT LID)

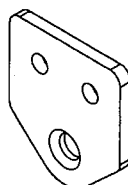


D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)

RELEASED
R 2010-02-26



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)

C	PARTS -19 & -21 ADDED (SHT 1& 4); CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4); C SYMM WAS C SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD, DRAFTING ERRORS		JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.		AJS	09.11.11
A	NEW ISSUE		AJS	09.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH			
CHECKED	JPH		DRAWING NO.	REV. C
MFG. APPR.	JPH		D3953	SHEET 1 OF 4
APPROVED	JPH		TITLE	SCALE
DE APPR.	JPH		GAS SPRING LID COMPONENTS	
DATE	10.01.29		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. HAS BEEN SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

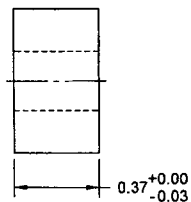
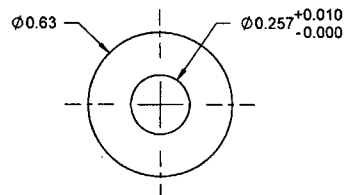
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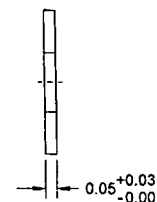
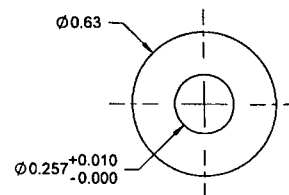
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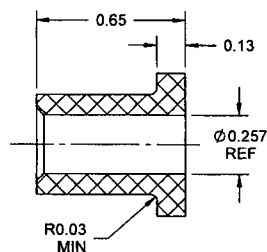
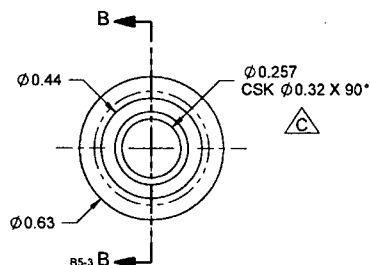
NOTE: Date & initial all entries



D3953-7 GAS SPRING SPACER

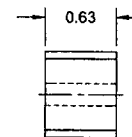
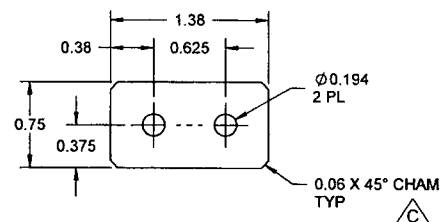


D3953-9 GAS SPRING WASHER



SECTION B-B 87-3

D3953-11 GAS SPRING SPACER



D3953-13 GAS SPRING SPACER

NOTES:

1) MATERIAL -7, -9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

RELEASED
2010-02-26

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV: C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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